

slp 18/05

Dart Aerospace Ltd.

Date: Thursday, 5/10/2007 2:23:38 PM
User: Kim Johnston

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: WEARSHOE
Job Number	: 32268		
Estimate Number	: 12737		
P.O. Number	: N/A	Part Number	: D353513
This Issue	: 5/10/2007 S.O. No. : N/A	Drawing Number	: D3535 UNDER REVIEW
Prsht Rev.	: NC	Project Number	: N/A
First Issue	: N/A Type : SMALL /MED FAB	Drawing Revision	: A/B # 07.05.10
Previous Run	: N/A	Material	: N/A
Written By	:	Due Date	: 5/17/2007 Qty: 4 Um: Each
Checked & Approved By	: <u>07.05.10</u>		
Comment	: Est Rev:A New Issue 07-02-15 JLM		

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
---------	-----------------------	---------------

1.0	M304S20GA	304/316 .040 Sheet
-----	-----------	--------------------



Comment: Qty.: 0.8930 sf(s)/Unit Total : 3.5721 sf(s)

304/316 .040 Sheet

(M304S20GA)

Batch: M101264 CW M101873 (3)

2.0	WATER JET	FLOW WATER JET
-----	-----------	----------------



Comment: FLOW WATER JET

1-Cut as per Dwg D3535

Dwg Rev: A/B

Prog Rev: B

2-Deburr if necessary

NOTE: Check Rev of DWG and flat pattern

SAD 07/05/12
PM 07/05/15

(4) (4)

3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
-----	-----	--



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

SAD 07/05/12

(4)

4.0	QC8	SECOND CHECK
-----	-----	--------------



Comment: SECOND CHECK

07.05.15 (4)

5.0	BRAKE NC	NC BRAKE
-----	----------	----------



Comment: NC BRAKE

1-Form on Brake as per Dwg D3535 using Jigs DT8261 and DT8326

2-Form joggle as per Dwg D3535 using Jig DT8158 Identify as D3535-13

MF 07-05-16 (4)
MF 07-05-16

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: 2 Date: 07/05/18
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Thursday, 5/10/2007 2:23:38 PM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: WEARSHOE

Job Number: 32268

Part Number: D353513

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

SB 07/05/16 (4)

7.0

POWDER COATING

POWDER COATING



Comment: POWDER COATING

Powder Coat Grey Sandtex (Ref: 4.3.5.6) as per QSI 005 4.3

M101601

07-05-17 (4)

8.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

07/05/18 (4)

9.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: _____

07/05/18 (4)

10.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

07/05/18 (4)

Job Completion



07-05-18

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

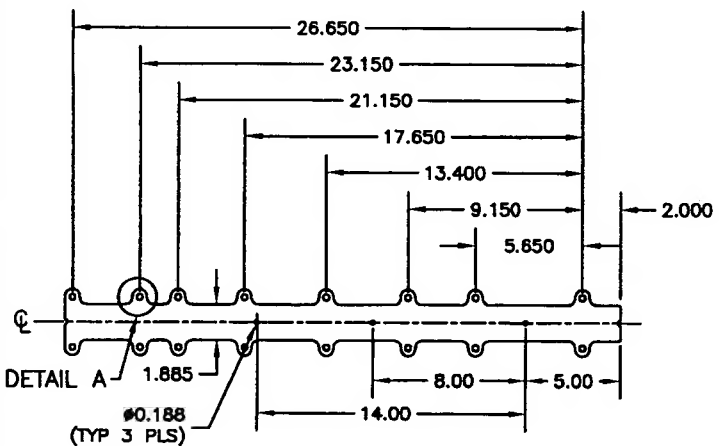
NOTE: Date & initial all entries

DART

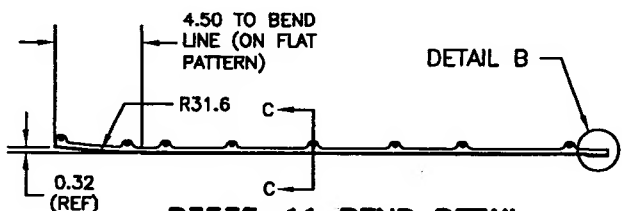
RELEASED

07.04.24

DESIGN	DRAWN BY	DART AEROSPACE USA, INC.	REV. B
CB	PH	PORT HADLOCK, WA	
CHECKED	APPROVED	DRAWING NO.	SHEET 1 OF 7
DATE	DATE	TITLE	SCALE
07.04.17	06.10.25	WEARSHOE	1:10
A	07.04.17	NEW ISSUE	
B		MOVE TAB OUTBOARD, ADD AMS SPEC	

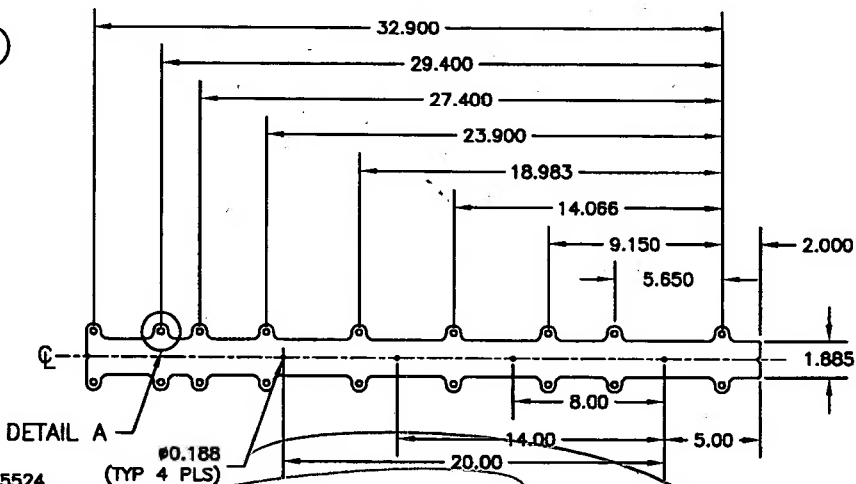


D3535-11F FLAT PATTERN

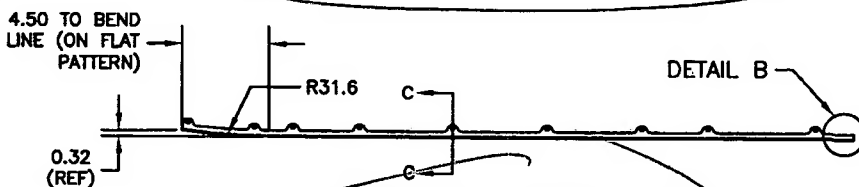


D3535-11 BEND DETAIL

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 32208



D3535-13F FLAT PATTERN



D3535-13 BEND DETAIL

NOTES

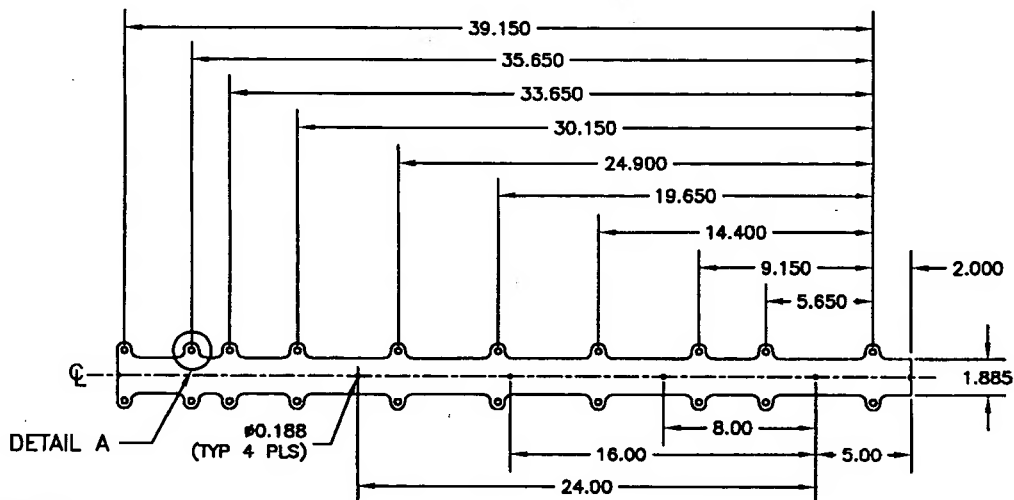
- 1) MATERIAL: AISI 304/316 SS SHEET PER AMS 5513 OR AMS 5524, 20 GAUGE (0.038 THICK) (REF DART SPEC M304S20GA)
- 2) FINISH: POWDER COAT GREY SANDTEX (4.3.5.6) PER QSI 005 4.3
- 3) PART IS SYMMETRICAL ABOUT C
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) ALL DIMENSIONS ARE IN INCHES
- 6) BREAK ALL SHARP EDGES TO 0.010 MAX
- 7) IDENTIFY WITH DART P/N USING WHITE FINE POINT PAINT MARKER
- 8) SEE PAGE 7 FOR DETAILS AND SECTION

DART

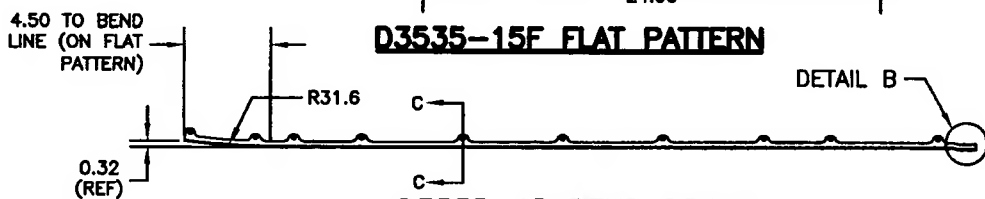
RELEASED

07.04.24

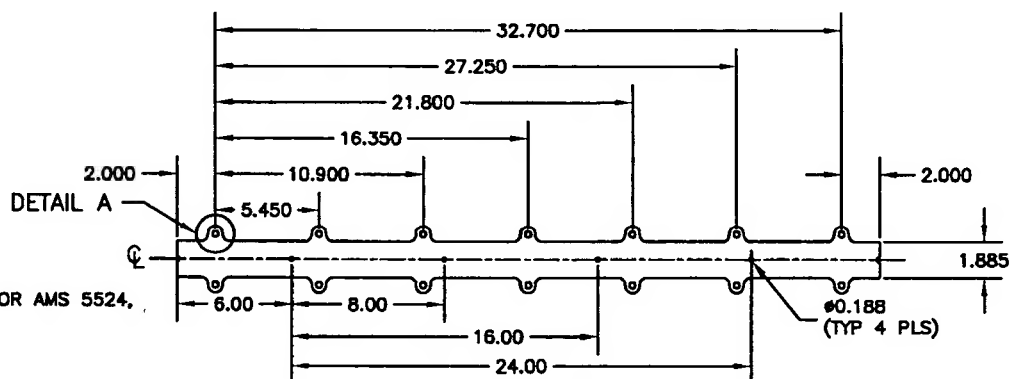
DESIGN	DRAWN BY	DART AEROSPACE USA, INC.	REV. B
CB	PH	PORT HADLOCK, WA	
CHECKED	APPROVED	DRAWING NO.	SHEET 2 OF 7
<i>[Signature]</i>	<i>[Signature]</i>	D3535	
DATE	TITLE	WEARSHOE	SCALE
07.04.17			1:10



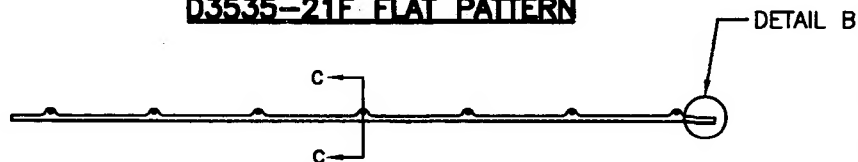
D3535-15F FLAT PATTERN



D3535-15 BEND DETAIL



D3535-21F FLAT PATTERN



D3535-21 BEND DETAIL

NOTES

- 1) MATERIAL: AISI 304/316 SS SHEET PER AMS 5513 OR AMS 5524, 20 GAUGE (0.038 THICK) (REF DART SPEC M304S20GA)
- 2) FINISH: POWDER COAT GREY SANDTEX (4.3.5.6) PER QSI 005 4.3
- 3) PART IS SYMMETRICAL ABOUT ϕ
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) ALL DIMENSIONS ARE IN INCHES
- 6) BREAK ALL SHARP EDGES TO 0.010 MAX
- 7) IDENTIFY WITH DART P/N USING WHITE FINE POINT PAINT MARKER
- 8) SEE PAGE 7 FOR DETAILS AND SECTION

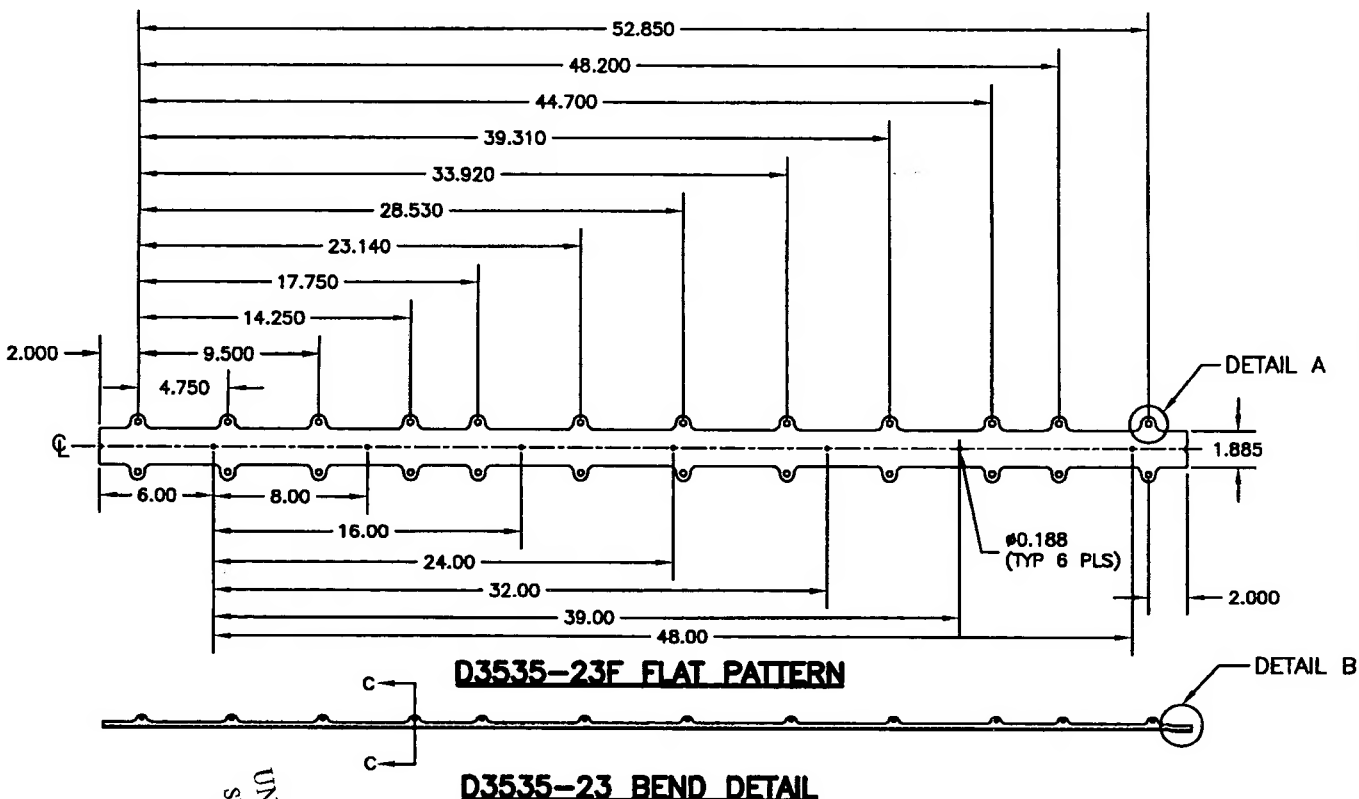
SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 32268

DART

DESIGN	C.B.	DRAWN BY	PH	DART AEROSPACE USA, INC.
CHECKED	<i>[Signature]</i>	APPROVED	<i>[Signature]</i>	PORT HADLOCK, WA
DATE	07.04.17	TITLE	WEARSHOE	REV. B
		DRAWING NO.	D3535	SHEET 3 OF 7
		SCALE	1:10	

RELEASED

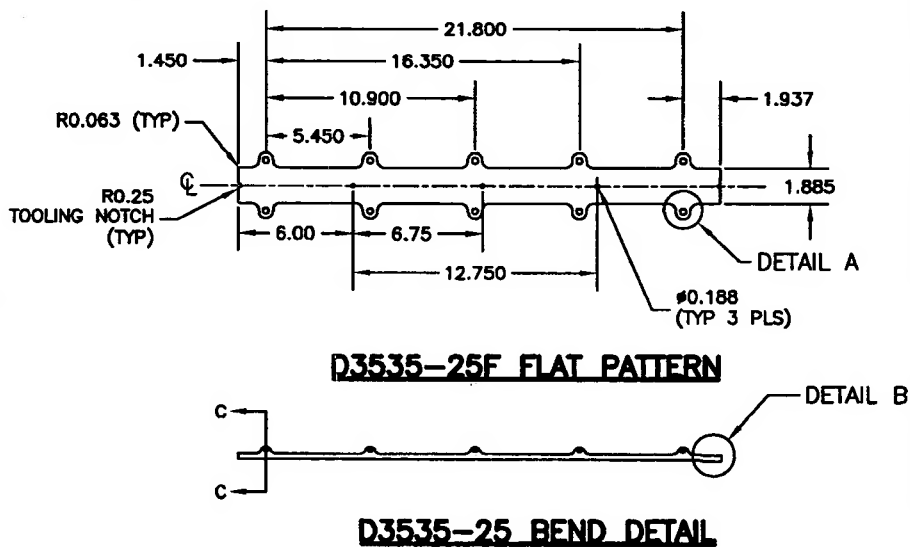
07.04.24



SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 32268

NOTES

- 1) MATERIAL: AISI 304/316 SS SHEET PER AMS 5513 OR AMS 5524, 20 GAUGE (0.038 THICK) (REF DART SPEC M304S20GA)
- 2) FINISH: POWDER COAT GREY SANDTEX (4.3.5.6) PER QSI 005 4.3
- 3) PART IS SYMMETRICAL ABOUT ϕ
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) ALL DIMENSIONS ARE IN INCHES
- 6) BREAK ALL SHARP EDGES TO 0.010 MAX
- 7) IDENTIFY WITH DART P/N USING WHITE FINE POINT PAINT MARKER
- 8) SEE PAGE 7 FOR DETAILS AND SECTION

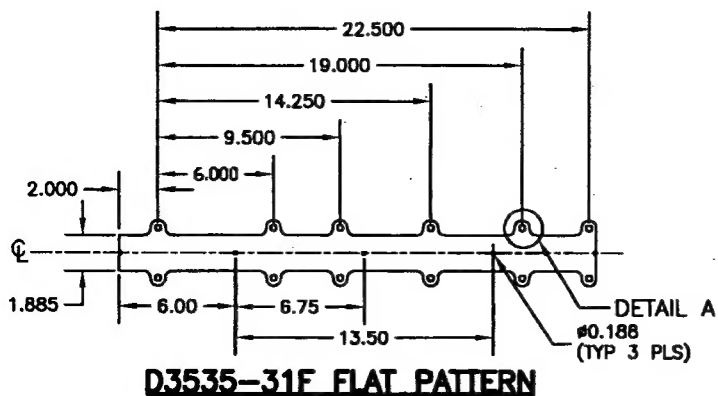


DART

RELEASED

07.04.24

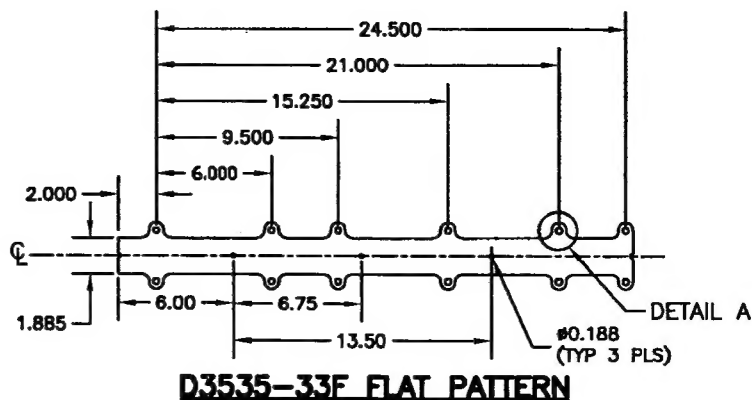
DESIGN	C.B.	DRAWN BY	PH	DART AEROSPACE USA, INC.
CHECKED	<i>[Signature]</i>	APPROVED	<i>[Signature]</i>	PORT HADLOCK, WA
DATE	07.04.17	DRAWING NO.	D3535	REV. B
		TITLE	WEARSHOE	SHEET 4 OF 7
		SCALE	1:10	



SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 32268

NOTES

- 1) MATERIAL: AISI 304/316 SS SHEET PER AMS 5513 OR AMS 5524, 20 GAUGE (0.038 THICK)
(REF DART SPEC M304S20GA)
- 2) FINISH: POWDER COAT GREY SANDTEX (4.3.5.6) PER QSI 005 4.3
- 3) PART IS SYMMETRICAL ABOUT ϕ
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) ALL DIMENSIONS ARE IN INCHES
- 6) BREAK ALL SHARP EDGES TO 0.010 MAX
- 7) IDENTIFY WITH DART P/N USING WHITE FINE POINT PAINT MARKER
- 8) SEE PAGE 7 FOR DETAILS AND SECTION

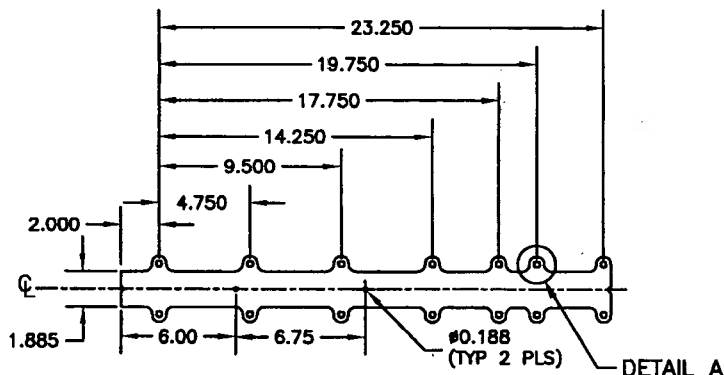


DART

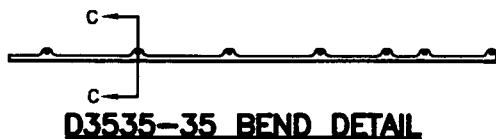
RELEASED

07.04.24

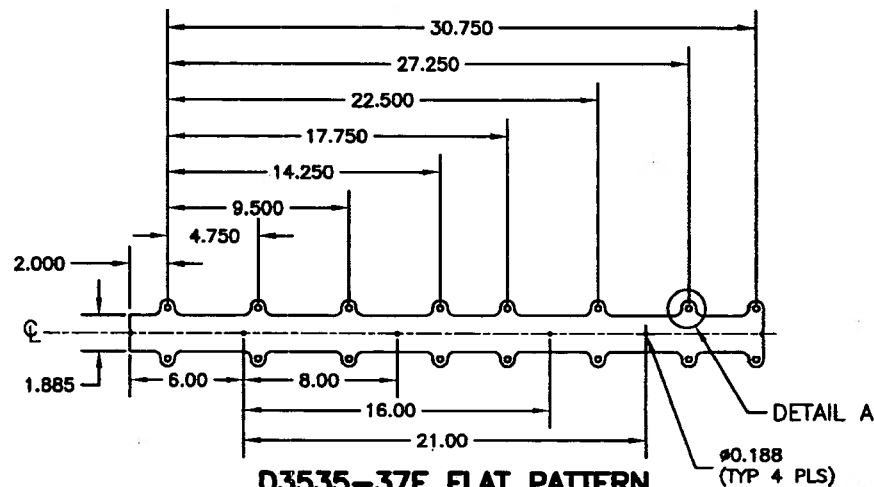
DESIGN	C.B.	DRAWN BY	PH	DART AEROSPACE USA, INC.
CHECKED	PH	APPROVED	PH	PORT HADLOCK, WA
DATE	07.04.17	DRAWING NO.	D3535	REV. B
TITLE	WEARSHOE	SHEET	5 OF 7	SCALE
				1:10



D3535-35F FLAT PATTERN



D3535-35 BEND DETAIL



D3535-37F FLAT PATTERN



D3535-37 BEND DETAIL

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO 32268

NOTES

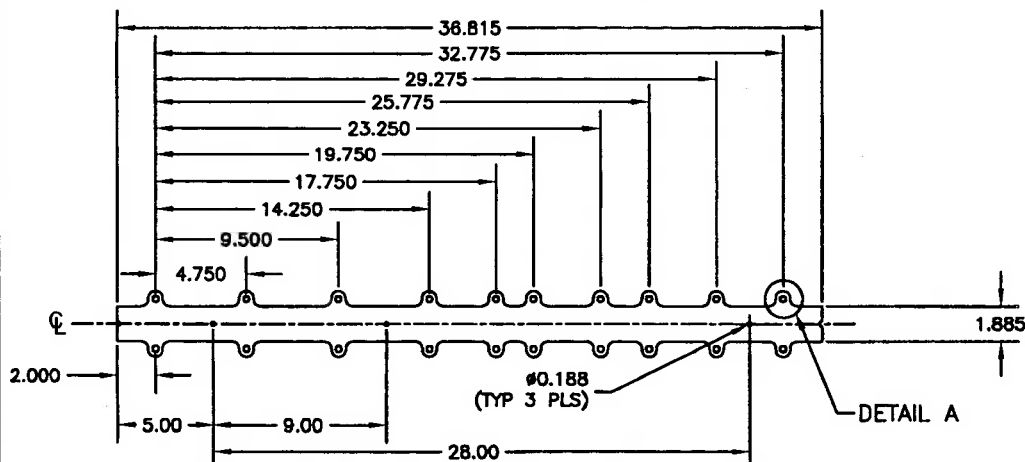
- 1) MATERIAL: AISI 304/316 SS SHEET PER AMS 5513 OR AMS 5524, 20 GAUGE (0.038 THICK) (REF DART SPEC M304S20GA)
- 2) FINISH: POWDER COAT GREY SANTEX (4.3.5.6) PER QSI 005 4.3
- 3) PART IS SYMMETRICAL ABOUT ϕ
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) ALL DIMENSIONS ARE IN INCHES
- 6) BREAK ALL SHARP EDGES TO 0.010 MAX
- 7) IDENTIFY WITH DART P/N USING WHITE FINE POINT PAINT MARKER
- 8) SEE PAGE 7 FOR DETAILS AND SECTION

DART

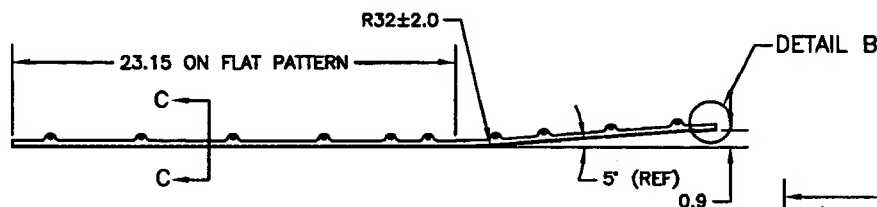
RELEASED

07.04.24

DESIGN	C.B.	DRAWN BY	PH	DART AEROSPACE USA, INC.
CHECKED	<i>[Signature]</i>	APPROVED	<i>[Signature]</i>	PORT HADLOCK, WA
DATE	07.04.17	DRAWING NO.	D3535	REV. B
		TITLE	WEARSHOE	SHEET 6 OF 7
		SCALE	1:10	

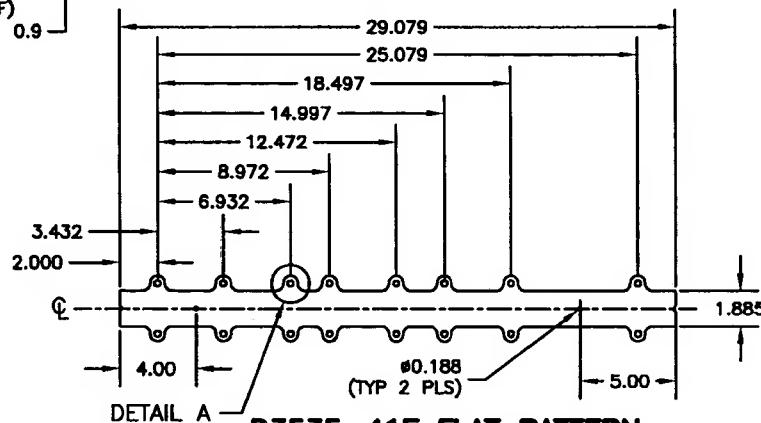


D3535-39F FLAT PATTERN

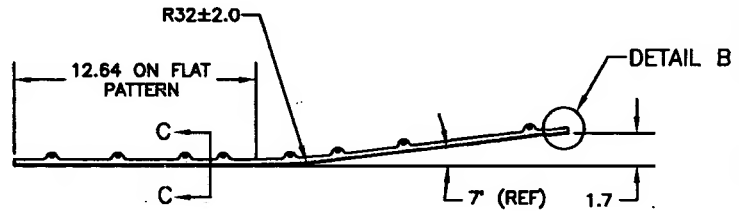


D3535-39 BEND DETAIL

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
NO. 32268
WORK ORDER



D3535-41F FLAT PATTERN



D3535-41 BEND DETAIL

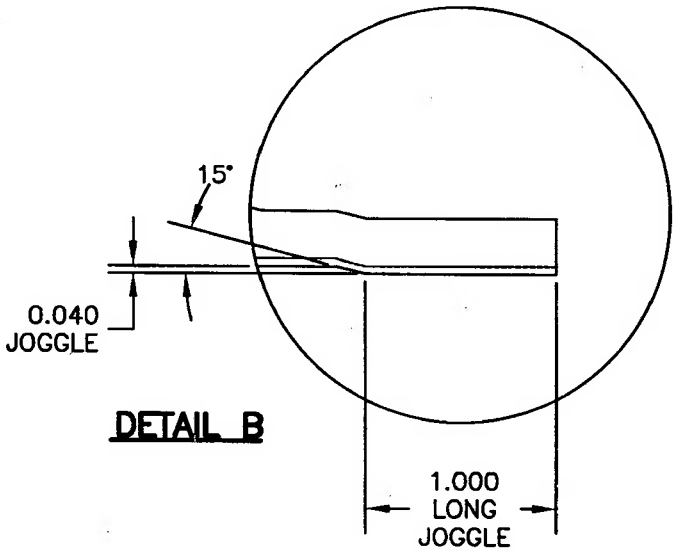
NOTES

- 1) MATERIAL: AISI 304/316 SS SHEET PER AMS 5513 OR AMS 5524, 20 GAUGE (0.038 THICK) (REF DART SPEC M304S20GA)
- 2) FINISH: POWDER COAT GREY SANDTEX (4.3.5.6) PER QSI 005 4.3
- 3) PART IS SYMMETRICAL ABOUT ϕ
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) ALL DIMENSIONS ARE IN INCHES
- 6) BREAK ALL SHARP EDGES TO 0.010 MAX
- 7) IDENTIFY WITH DART P/N USING WHITE FINE POINT PAINT MARKER
- 8) SEE PAGE 7 FOR DETAILS AND SECTION

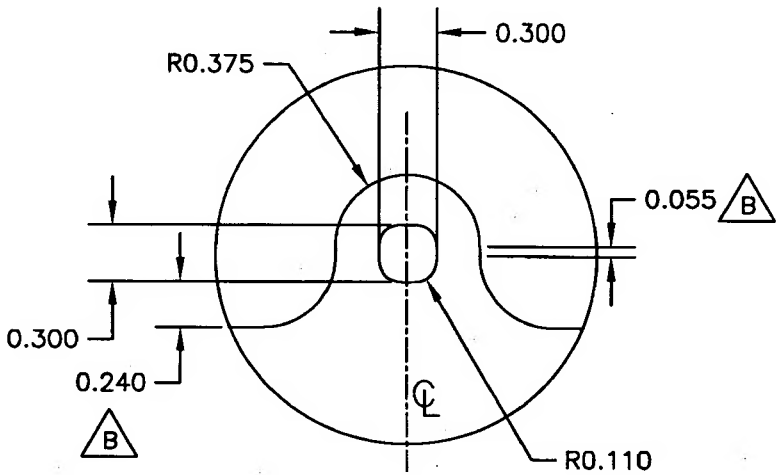


DESIGN	C.B.	DRAWN BY	PH	DART AEROSPACE USA, INC.	REV. B
CHECKED	<i>[Signature]</i>	APPROVED	<i>[Signature]</i>	PORT HADLOCK, WA	
DATE	07.04.17			DRAWING NO. D3535	SHEET 7 OF 7
				TITLE WEARSHOE	SCALE 1:1

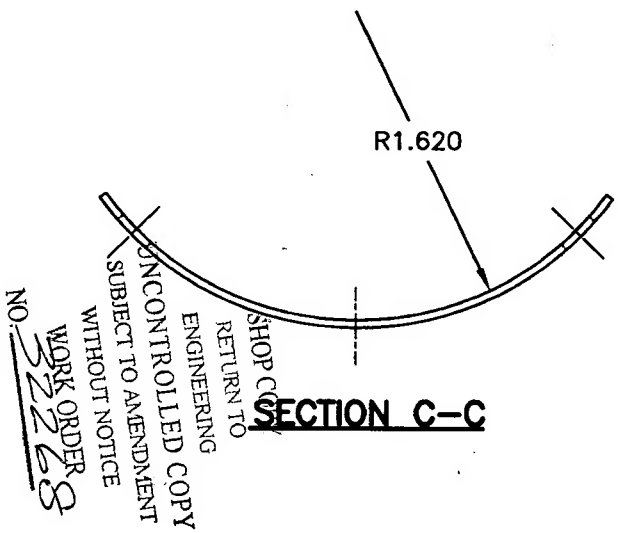
RELEASED
07.04.24 *[Signature]*



DETAIL B



DETAIL A



SECTION C-C

DART AEROSPACE LTD		Work Order:	
Description: Bearpaw <i>Wear Shoe</i>		Part Number:	D3535-13
Inspection Dwg: D3535 Rev:		Page 1 of 1	

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

Inspection Sheet Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
A 32.900	+/- 0.010	32.900	✓		M-T	
B 29.400	+/- 0.010	29.400	✓		M-T	
C 27.400	+/- 0.010	27.400	✓		M-T	
D 23.900	+/- 0.010	23.900	✓		M-T	
E 18.983	+/- 0.010	18.980	✓		M-T	
F 16.066	+/- 0.010	16.060	✓		M-T	
G 9.150	+/- 0.010	9.149	✓		Vern	
H 5.650	+/- 0.010	5.648	✓		Vern	
I 2.000	+/- 0.010	2.007	✓		Vern	
J 1.885	+/- 0.010	1.889	✓		Vern	
K 5.00	+/- 0.030	5.00	✓		Vern	
L 8.00	+/- 0.030	8.00	✓		Vern	
M 14.00	+/- 0.030	13.99	✓		Vern	
N 20.00	+/- 0.030	19.99	✓		Vern	
O 0.300	+/- 0.010	0.295	✓		Vern	
P 0.300	+/- 0.010	0.297	✓		Vern	
Q Ø 0.188	+0.005 -0.001	Ø 0.190	✓		Vern	
R						
S						
T						
U						
V						
W						
X						
Y						

Measured by: <i>SAD</i>	Audited by: <i>[Signature]</i>	Prototype Approval:	N/A
Date: <i>07/05/12</i>	Date: <i>07.05.12</i>	Date:	N/A

Rev	Date	Change	Revised by	Approved
A	04.01.09	New Issue	KJ/RF	